

FIG. 1

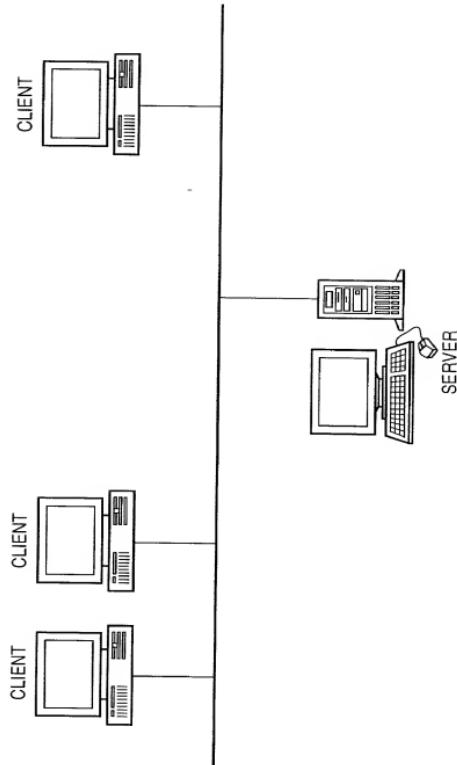


FIG. 2

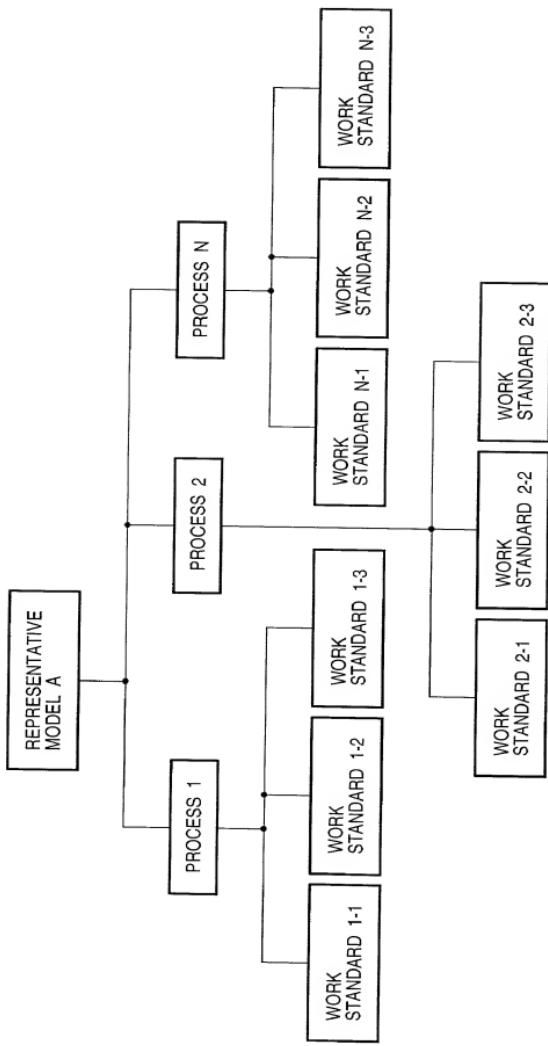


FIG. 3

302

WORK STANDARD 01 CREATION

301

APPLIED

300

FIG. 4

STRUCTURE OF MASTER FILE

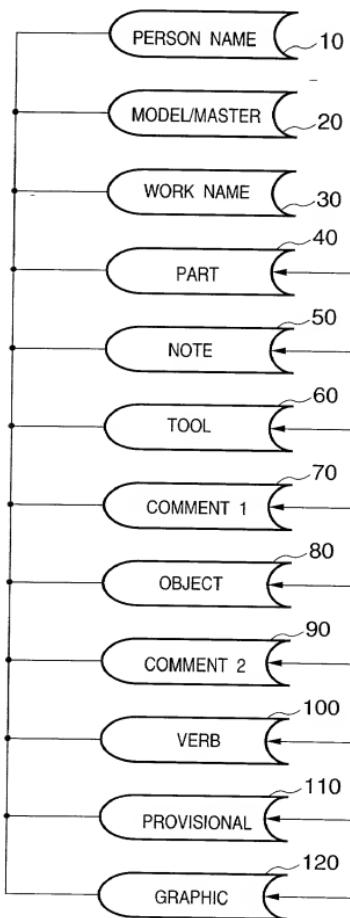


FIG. 5

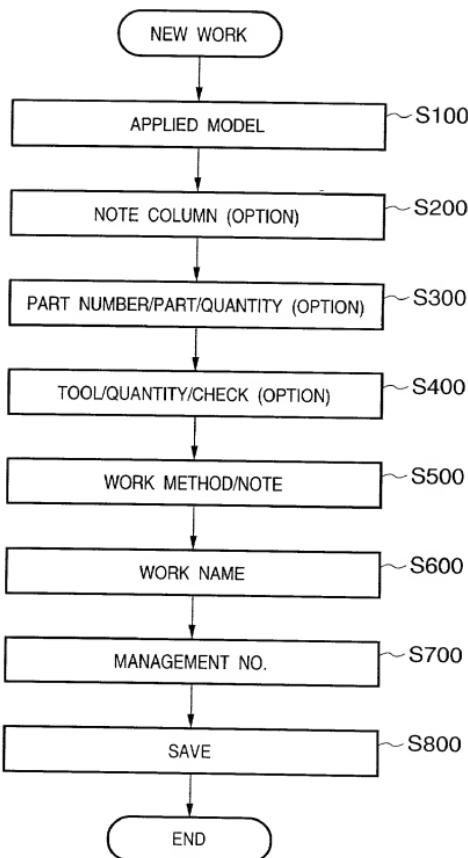


FIG. 6

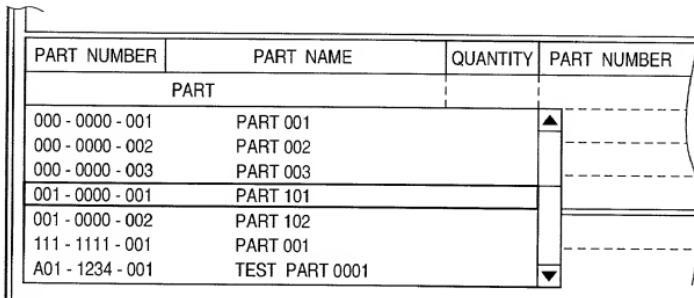
SELECTION OF APPLIED MODEL	
LIST OF APPLIED MODELS	
BJC-4200 SYSTEM	
BJC-420J	
BJC-420J (BLACK)	
BJC-4300	
BJC-430J	
BJC-4200LX	
A250 II Q	
BJC-4200	
OK	CANCEL

FIG. 7

WORK STANDARD 01 CREATION				
APPLIED	BJC-420U	BJC-420U(BLACK)	BJC-430U	
PART NUMBER	PART NAME	QUANTITY	PART NUMBER	PART NAME
				▲

302

FIG. 8



PART NUMBER	PART NAME	QUANTITY	PART NUMBER
PART			
000 - 0000 - 001	PART 001		
000 - 0000 - 002	PART 002		
000 - 0000 - 003	PART 003		
001 - 0000 - 001	PART 101		
001 - 0000 - 002	PART 102		
111 - 1111 - 001	PART 001		
A01 - 1234 - 001	TEST PART 0001		

FIG. 9

• WORK NAME	GE _____
• CANDIDATES	
<p>(SET ORIGINAL GLASS PROTECTIVE SHEET)</p> <p>(HOOK DEVELOPING RAIL RETURN SPRING)</p> <p>(HOOK DEVELOPING RAIL RETURN SPRING(AFTER))</p> <p>(SET ORIGINAL GLASS TABLE)</p> <p>(SET ORIGINAL TABLE PROTECTIVE SHEET)</p> <p>(CHECK NO TONER IN DEVELOPER)</p> <p>(CHECK ERROR IN DEVELOPER)</p> <p>(LOCK DEVELOPER)</p>	



FIG. 10

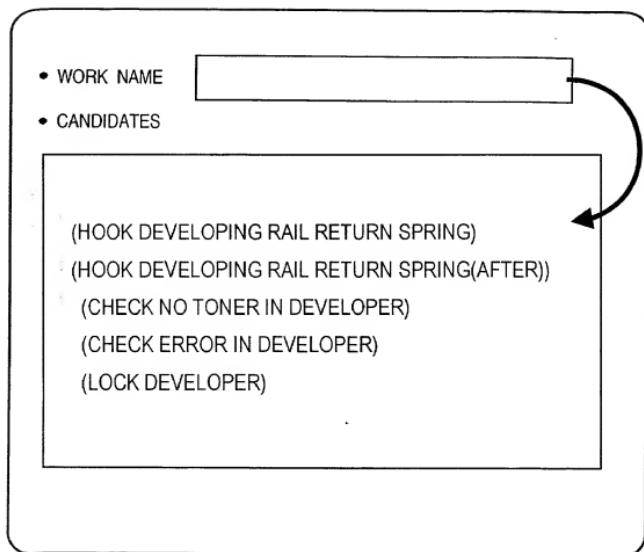


FIG. 11

1100

WORK STANDARD SYSTEM	
WORK NAME :	
WORK METHOD :	
1101 ~	(COMMENT 1)
1102 ~	(OBJECT)
1103 ~	(COMMENT 2)
1104 ~	(VERB)
00	*
01	
NOTE, STANDARD / REQUIRED QUALITY :	
1106	
1107	
<input type="button" value="OK"/> <input type="button" value="CANCEL"/>	

1105
1105a
1105b

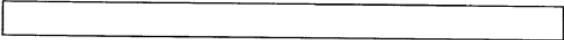
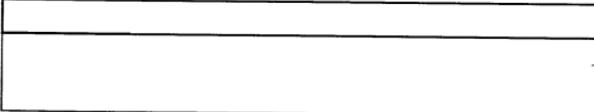
1108

1100

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FIG. 12

TO 65001-92455760

WORK STANDARD SYSTEM	
WORK NAME :	
WORK METHOD :	
	
	
00	※
01	

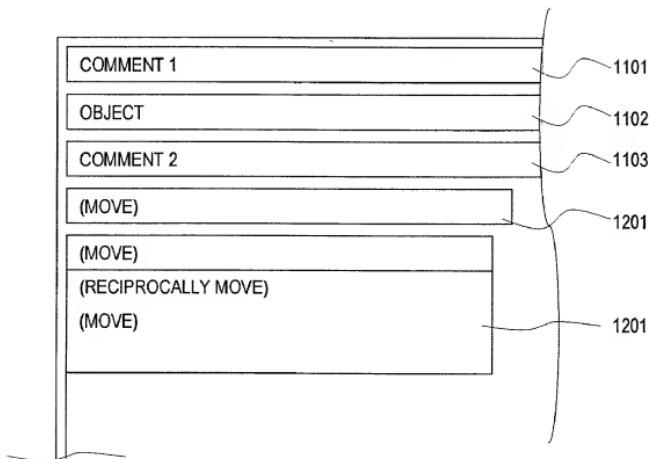
1201

1202

1105b

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FIG. 13



100001-92755260

FIG. 14

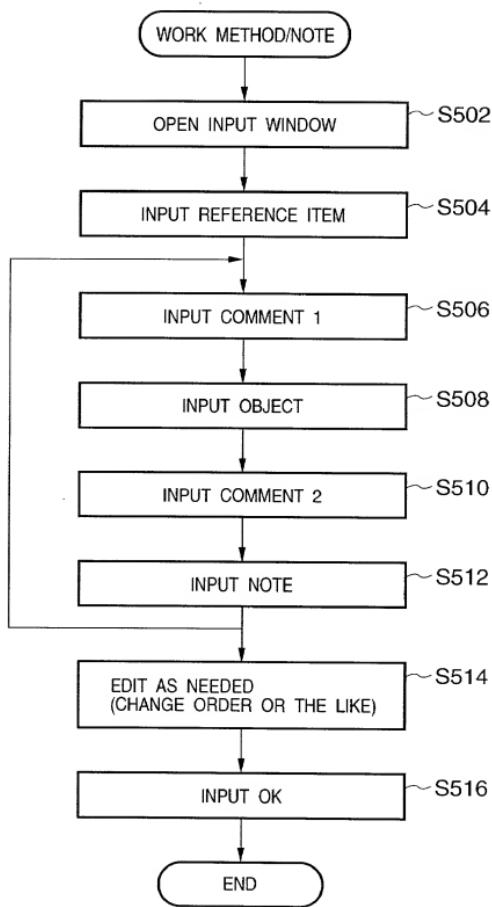


FIG. 15

00	*
01	DO zzzz SUCH THAT xxxx AT www POSITION BECOMES yyyy
02	WIND AV CORD
03	CONFIRM 100V SYSTEM
04	SET CRG HOLDER

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FIG. 16

NOTE, STANDARD / REQUIRED QUALITY

NOTE |

1601

SEPARATION GRIPPER MOVES SLOWLY WITHOUT GRIPPER SPRING OF ASFu

DON'T PULL TAPE TOO STRONG TO MAKE SIDE GUIDE LOOSE

DON'T HOOK PAPER GUIDE u ON SHEET HOLDER

BEWARE OF IMITATIONS

BEWARE OF IMITATIONS(Color Style Write

1602

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FIG. 17

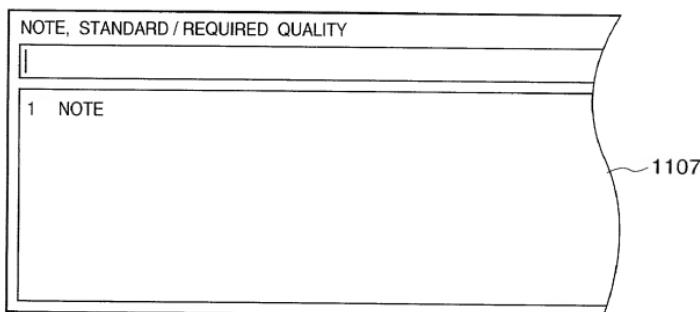
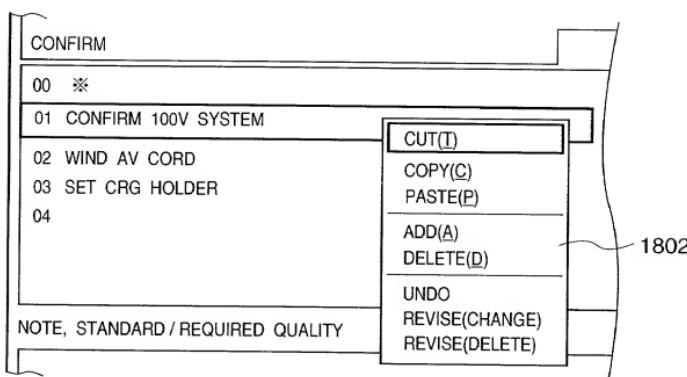


FIG. 18



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FIG. 19

CONFIRM	
00	※
01 WIND AV CORD	
02 CONFIRM 100V SYSTEM	
03 SET CRG HOLDER	
04	
NOTE, STANDARD / REQUIRED QUALITY	

FIG. 20

ROUTER: 92/35260

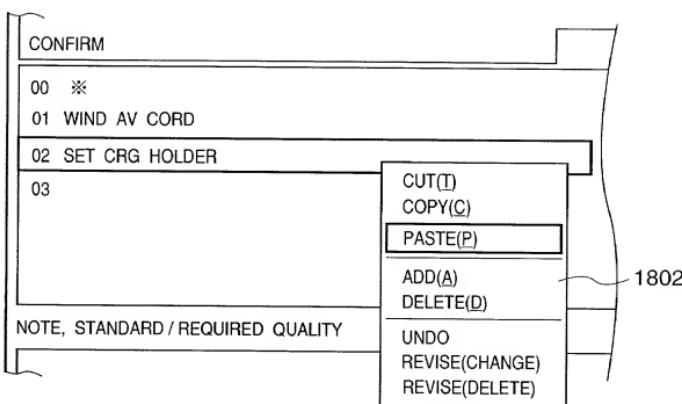


FIG. 21

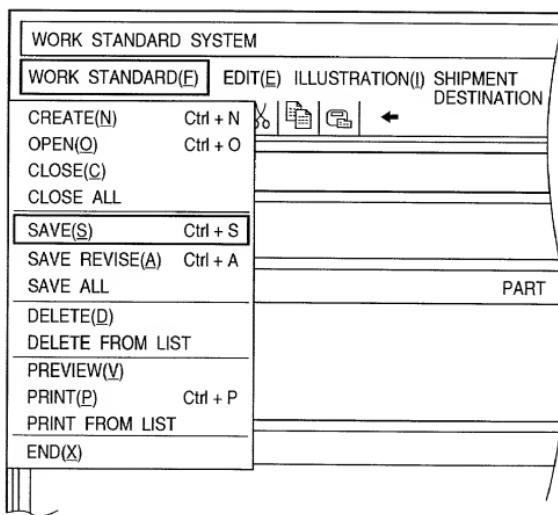


FIG. 22

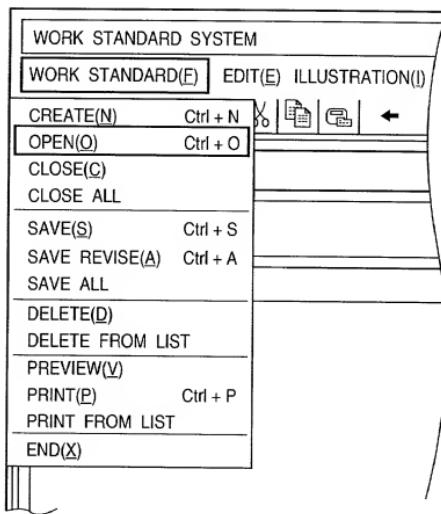


FIG. 23

WORK STANDARD SYSTEM

LATEST REVISION NUMBER ALL

MANAGEMENT NO.	REVISION NUMBER	WORK NAME	DATE OF REGISTRATION
SO - 04 - 01(4) - E	01	SET ASFe	1997/09/13
SO - 01 - 01(3) - E	01	SET BASE TRAY	1997/09/01
SO - 01 - 03 - E	01	SET BASE TRAY	1997/09/01
SO - 01 - 04 - E	01	SET BASE TRAY	1997/09/01

◀ ▶

SO - 06 - 01 - E	01	WIRING	1997/09/01
SO - 06 - 02 - E	01	WIRING	1997/09/01
SO - 06 - 03 - E	01	WIRING	1997/09/01
SO - 07 - 01(2) - E	01	GREASING	1997/09/01
SO - 08 - 01 - E	01	SET RAIL	1997/09/01

◀ ▶

OK CANCEL

2301

FIG. 24

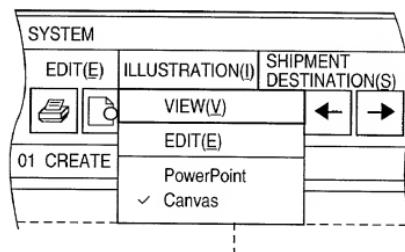


FIG. 25

302

WORK STANDARD 01 CREATION	
<input type="checkbox"/> APPLIED	
PART NUMBER	PART NAME
303	
TOOL / TREATMENT DEVICE	
WORK PROCEDURE	
FILE NAME : <input type="text"/> <input type="button" value="UPDATE"/> <input type="button" value="CLEAR"/> <input type="button" value="CLOSE"/>	
No.	2501
	2502
	2503
	2504
REVISION NUMBER	
01	CREATED
CONTENTS OF REVISION	
DATE	
1997/09/25	
PERSON IN CHARGE	
APPROVE	
WORK NAME	
MANAGEMENT NO.	

FIG. 26

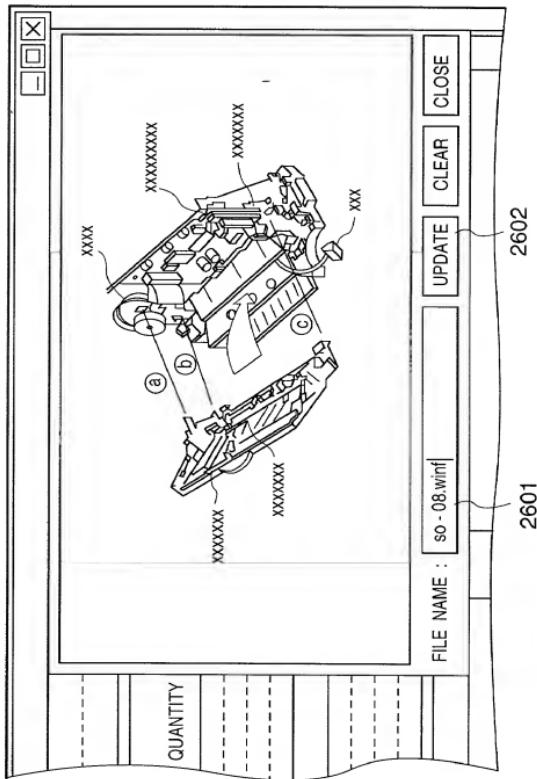


FIG. 27

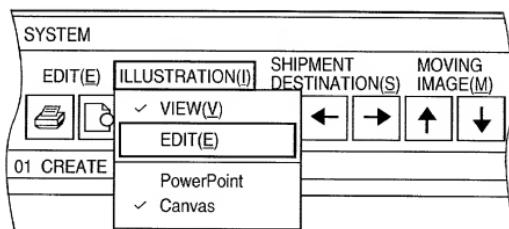


FIG. 28

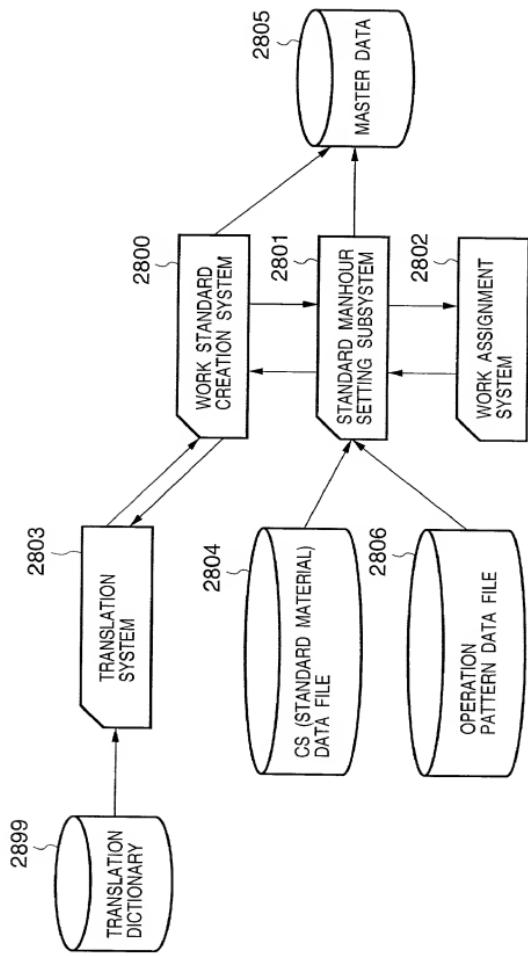


FIG. 29

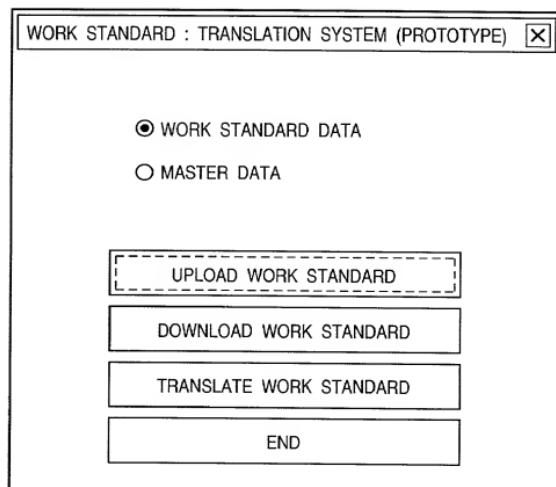


FIG. 30

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TRANSLATION OF WORK STANDARD		3001 3002 3003 3004	
REPRESENTATIVE MODEL NAME :	A252	DISPLAY DATA	DISPLAY LANGUAGE
PREPUCES NAME :	PLATEN UNIT	<input checked="" type="radio"/> ALL	<input type="radio"/> JAPANESE
	TOTAL UNIT	<input type="radio"/> UNTRANSLATED	<input checked="" type="radio"/> ENGLISH
	ASSEMBLY	<input type="radio"/> UNCHECKED	
MANAGEMENT NO.	REVISION NUMBER	WORK NAME	AUTOMATIC TRANSLATION CHECK
PT - 010 - 010	01	SET CLEANER UP	X X
PT - 010 - 020	01	SET CLEANER UP	X X
PT - 010 - 030	01	SET CLEANER UP	X X
PT - 070 - 030	01	ASSEMBLE CHANGER/ARM	X X
PT - 080 - 010	01	SET TRANSMISSION ROLLER	X X
PT - 090 - 010	01	SET TRANSMISSION ROLLER	X X
PT - 100 - 010	01	SET SHEET HOLDER	X X
SELECT ALL		<input type="checkbox"/> CANCEL SELECT	<input type="checkbox"/> VIEW
		<input type="checkbox"/> TRANSLATE	<input type="checkbox"/> CLOSE
		TRANSLATE ALL	
		3007 3008 3005	
		3006	

FIG. 31

FIG. 32

3201	WORK PROCEDURE	
	VOICE(W) JAPANESE	
3202	WORK PROCEDURE	
	アレード"い"→"ねをアレード"い"→"の ① 部に引っ掛ける 01 アレード"い"→"ネをアレード"い"→"の ① 部に引っ掛ける 02 アレード"い"→"を矢印一 ② 方向に矢印"させ引っ掛け"させ引っかけ 03 アレード"い"→"軸先端がアレード"ホダ"→"先端まで圧入されていることを確認する	
3203	ENGLISH	
	Procedure The blade lever spring hooks to ① of the blade lever. 01 The blade lever spring hooks to ① of the blade lever. 02 Side the blade lever in the direction of arrow ② and there is no catch and n.... 03 Check press-fitting the blade lever shaft leading edge to the braid folder leading ed....	
3204		◀ ▲
	TRANSLATE <input type="checkbox"/> OK <input type="checkbox"/> CANCEL	

FIG. 33

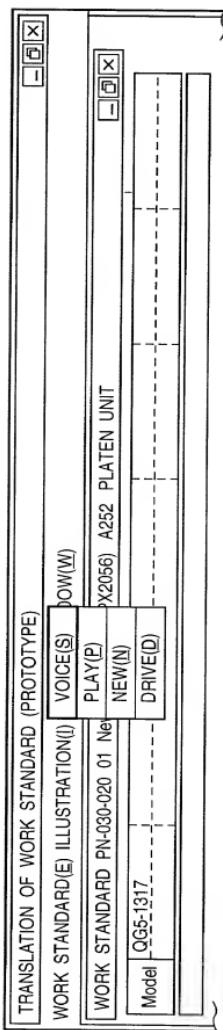


FIG. 34

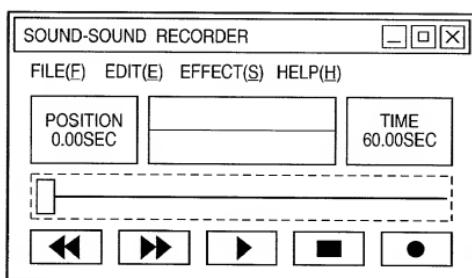


FIG. 35

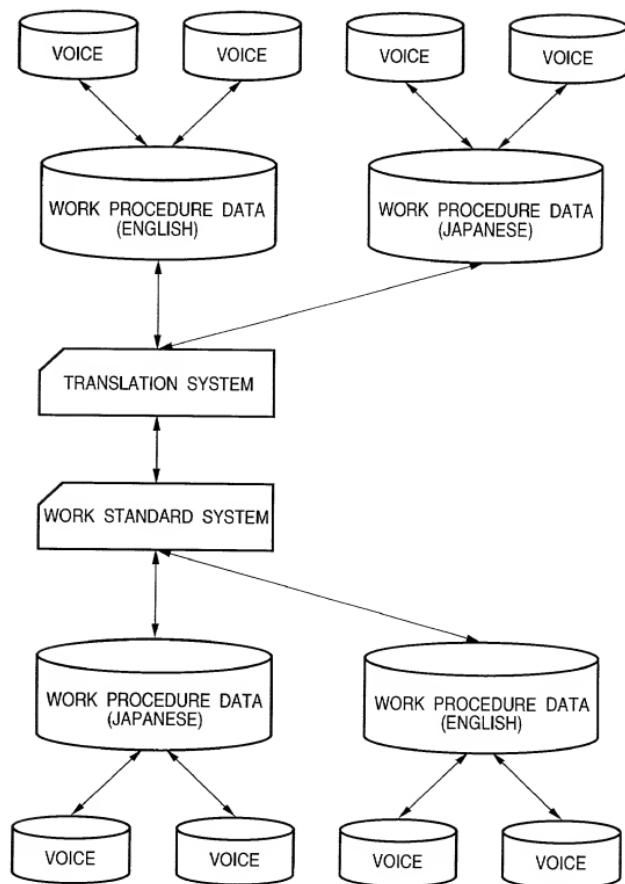


FIG. 36

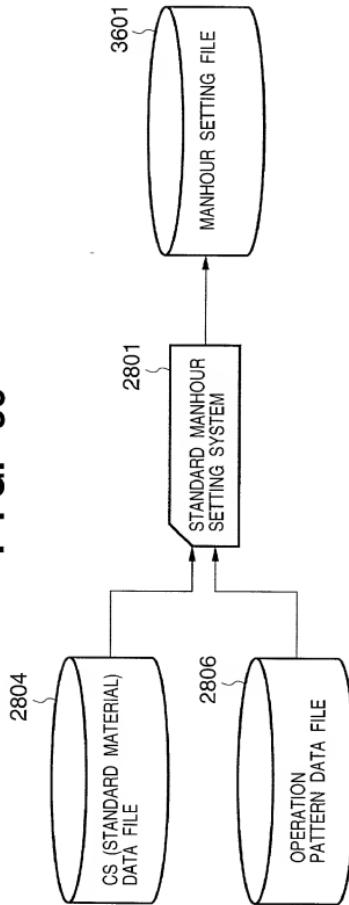


FIG. 37

No.	ELEMENT WORK NAME	FREQUENCY	MANHOUR	CS	SET CONDITION

FIG. 38

STANDARD MATERIAL DATA

COMMENT 1	OBJECT	COMMENT 2	VERB	SET	CONDITION DATA

FIG. 39

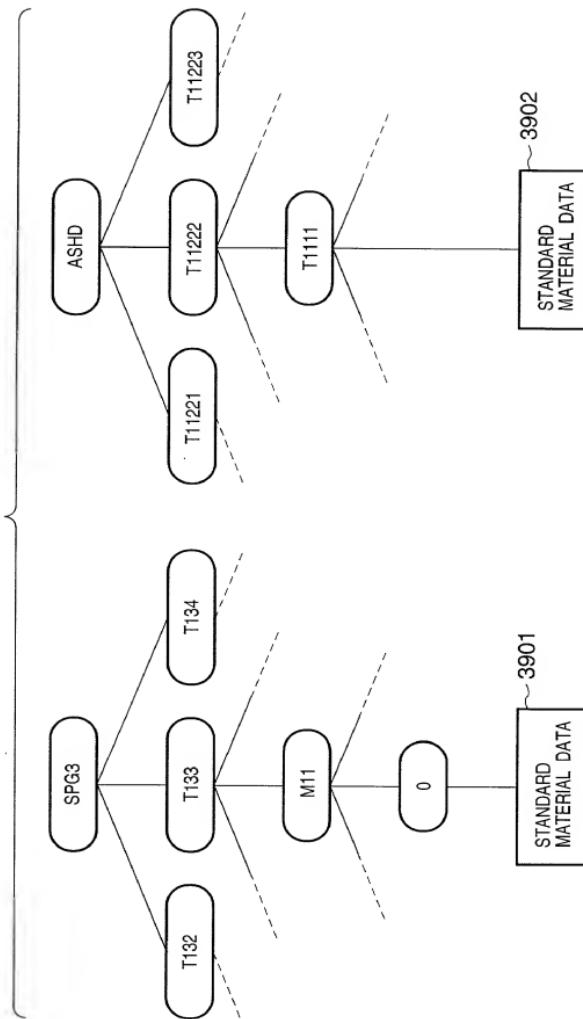


FIG. 40

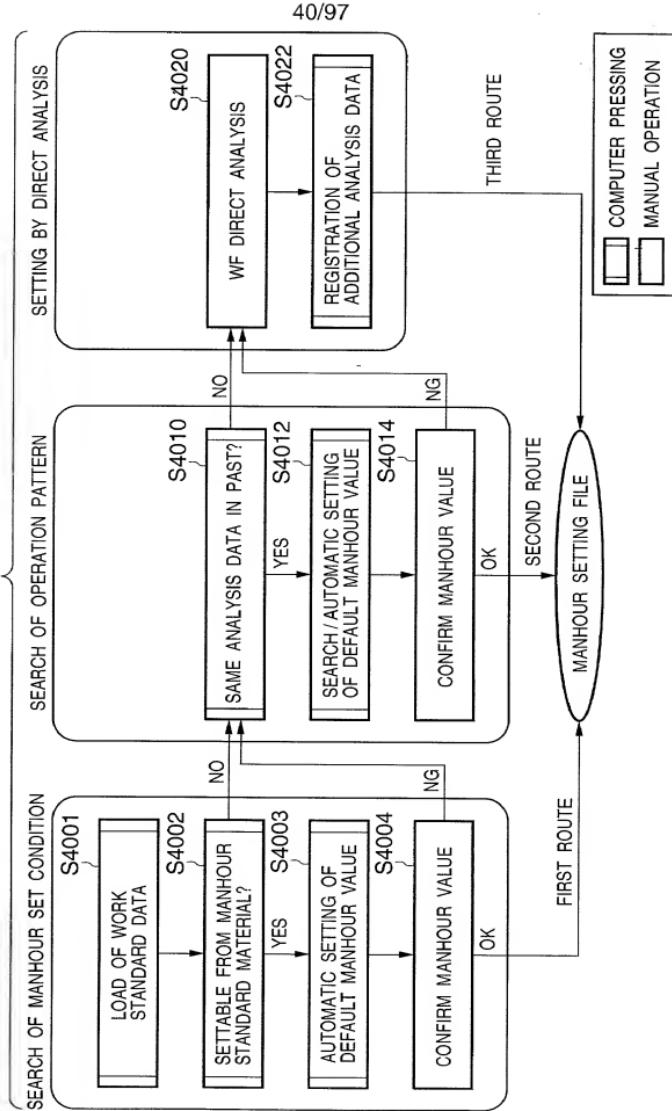


FIG. 41

3601

DATA LOAD

• ELEMENT WORK NAME

No	COMMENT 1	OBJECT	COMMENT 2	VERB
1		LOAD SPRING	IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING	SET
2	OF TREATMENT DEVICE	SW		TURN ON
3		SEPARATION ROLLER	IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING	SET
4	OF TREATMENT DEVICE	SW		TURN OFF
5		SEPARATION ROLLER	FROM TREATMENT DEVICE	DETACH

FIG. 42

3601

UNIT WORK NAME : SEPARATION ROLLER ATTACHMENT						
No.	ELEMENT WORK NAME	FREQUENCY	MANHOUR	CS	SET CONDITION	
1	(SET LOAD SPRING IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING)	1	1	41	SPG3	T133 / M11 / 0
2	(TURN ON SW OF TREATMENT DEVICE)	1	1	8		
3	(SET SEPARATION ROLLER SHAFT IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING)	1	1	37	ASHD	T11222 / T1111
4	(TURN OFF SW OF TREATMENT DEVICE)	1	1	8		
5	(DETACH SEPARATION ROLLER SHAFT FROM TREATMENT DEVICE)	1	1	16	PUMB	T2111 / T111111

MATCH

SEARCH KEYWORD (KW)

No.	COMMENT 1	OBJECT	COMMENT 2	VERB	MANHOUR STANDARD MATERIAL	TIME VALUE
1	*	SPRING	TO *	SET	SPG3 T133/M11/0	41RU
2	*	*	TO *	SET	ASHED T11222/T1111	37RU
3	*	*	FROM *	DETACH	PUMQ T2111/T11111	16RU
4	*	E-RING	*	SET	RIN2 T11211/SO	76RU
5	*	CONNECTOR	*	INSERT	CONN T11211/SO	41RU
6	*	*	*	SCREW TIGHTLY	SCR6 M211/1	23RU

FIG. 43

3601

UNIT WORK NAME : SEPARATION ROLLER ATTACHMENT						
No.	ELEMENT WORK NAME	FREQUENCY	MANHOUR	CS	SET CONDITION	
1	(SET LOAD SPRING IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING)	1	1	41	SPG3	T133/M11/0
2	(TURN ON SW OF TREATMENT DEVICE)	1	1	8		/GET:-50E/M:-10E
3	(SET SEPARATION ROLLER SHAFT IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING)	1	1	37	ASHD	T1122/T1111
4	(TURN OFF SW OF TREATMENT DEVICE)	1	1	8		/GET:-50E/M:-10E
5	(DETACH SEPARATION ROLLER SHAFT FROM TREATMENT DEVICE)	1	1	16	PUMB	T2111/T111111

MATCH

No	COMMENT 1	OBJECT	COMMENT 2	VERB	VERB PATTERN	TIME VALUE
1	TREATMENT DEVICE	SW		TURN ON	/GET-.50E/M-.10E	8RU
2	TREATMENT DEVICE	SW		TURN OFF	/GET-.50E/M-.10E	8RU
3		READING OPERATION UNIT		CLOSE	/GET-.50E/M-.50E	10RU
4		CRG DOOR		CLOSE	/GET-.50E/M-.50E	10RU
5		READING OPERATION UNIT		CLOSE	/GET-.50E/M-.50E	10RU
6		POWER CODE		PULL OUT	/GET-.50Eg2/M-.10E	16RU
7		POWER CODE FOR MEASUREMENT		PULL OUT	/GET-.50Eg2/M-.10E	16RU

FIG. 44

3601

FIG. 45

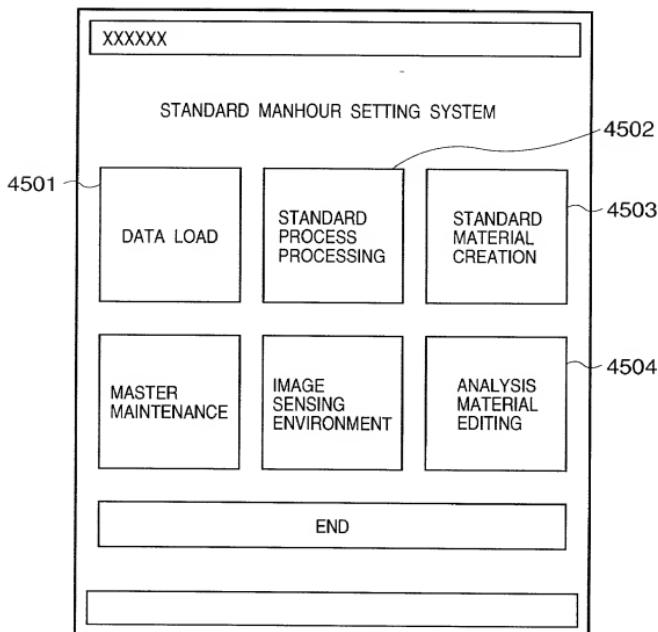


FIG. 46

PRODUCT NUMBER	WORK STANDARD	PRODUCT SYMBOL	NAME	PREVIOUS LOAD DATE
0-CLOCK	XXXX	XX	XXXX	XXX
XXXXXX		BL-OLD	SET IN 1996	
xyz - test				
test - 01				
test - AMI				

4601

4602 4603 4604 4605

4609 4610

4611

4612

ALL DESIGNATE :

PRODUCT NUMBER : NAME :

OK

SELECT

CANCEL

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FIG. 47

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S	PROVISIONAL MANAGEMENT NO.	PRODUCTION MANAGEMENT NO.	TOTAL	WORK NAME	COMPONENT SYMBOL	PREVIOUS LOAD DATE	LOADER
4705a	4705b	4706	4707	4708	4701	4702	4703
4704							

SET MANHOUR >

XXXXXX

FILE(F) EDIT(E) EXECUTE(S) VIEW(V)

BJC - 4200 → BJC - 970909

FIG. 48

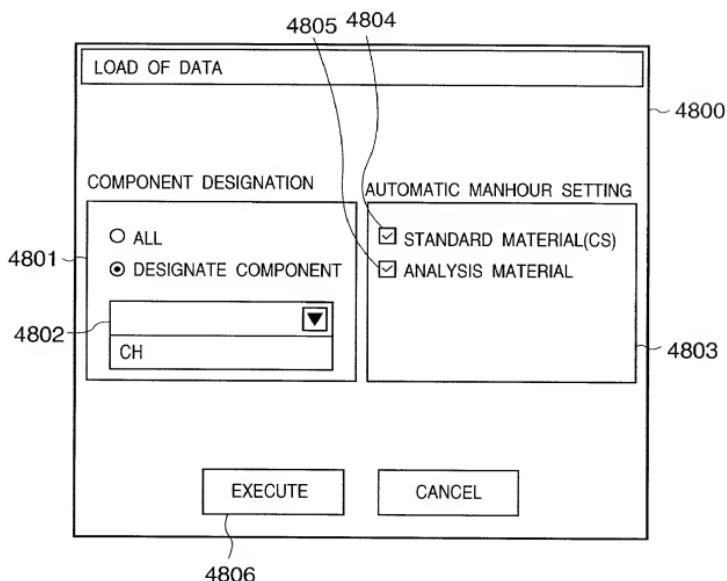


FIG. 49

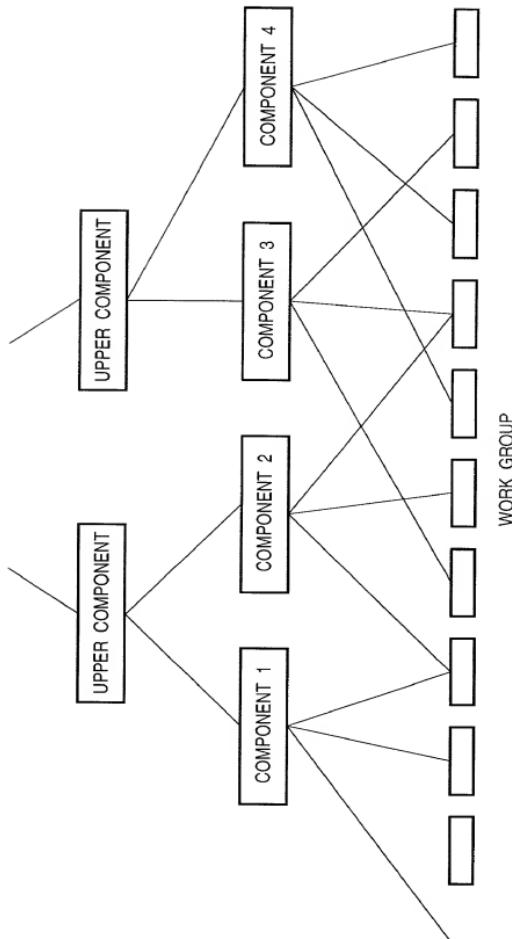


FIG. 50

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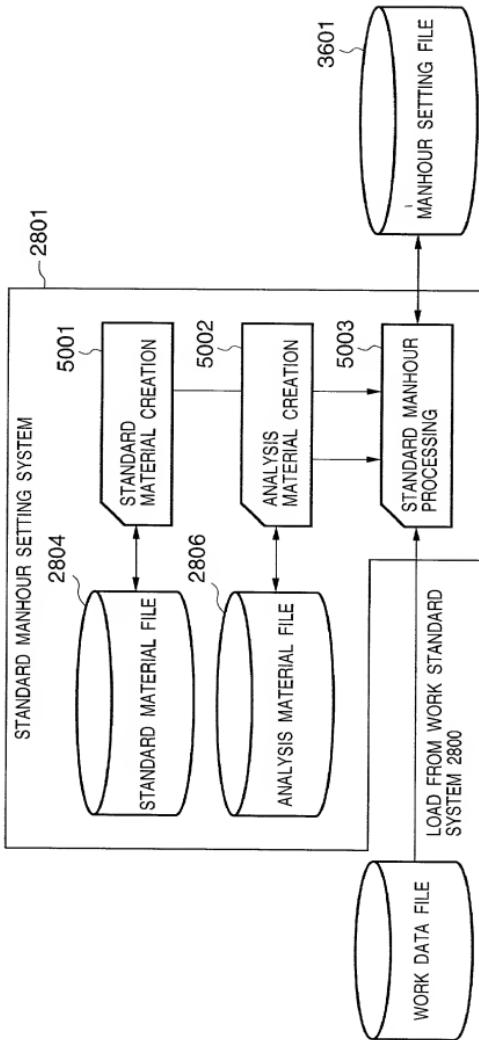


FIG. 51

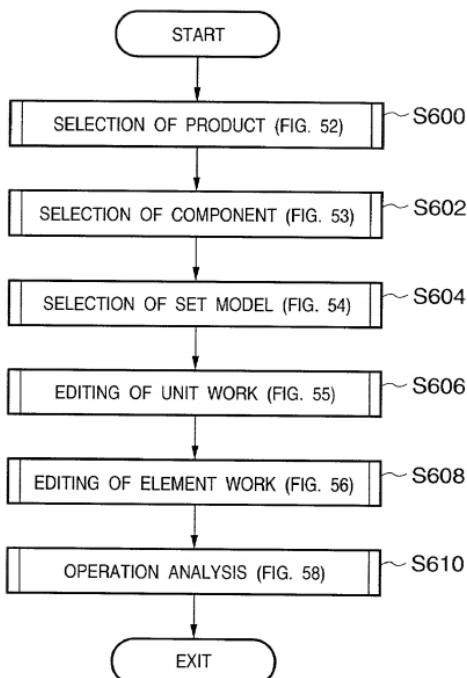


FIG. 52

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SELECTION OF PRODUCT	
FILE(F)	EDIT(E)
<input type="checkbox"/>	<input type="checkbox"/>
►	PRODUCT SYMBOL
BJ-970909	XXXX
BJ-STAND	
BJ-test	
BJ250	
ST01	
STAND01	
NAME	
TEST 01 Standard	
250 TESTS	
STAND PRODUCT	
PREVIOUS UPDATE DATE	
1997/09/22 10:17:30	
1997/09/12 15:09:09	
1997/09/18 10:38:14	
1997/09/17 17:58:59	
1997/09/12 16:02:34	
1997/09/19 15:46:04	
SET MANHOUR	
EXTRACT DATA	
CREATE HOST TRANSFER	
ANALYZE DATA	
END	

5201

FIG. 53

SELECTION OF COMPONENT	
FILE(E)	EDIT(E)
<input type="checkbox"/>	<input type="checkbox"/>
PRODUCT SYMBOL : BJ - 4200	
COMPONENT SYMBOL	NAME : BJ - 4200
► BK	NAME
▼ CH	NAME
KO	NAME
XXXXX	
CHECK PROCESS	
PACKAGE	
NAME : BJ - 4200	
PREVIOUS UPDATE DATE	
1997/09/22 11:09:59	
1997/09/12 11:09:59	
1997/09/18 11:21:07	
<input type="checkbox"/>	NEXT
<input type="checkbox"/>	DOWNLOAD
<input type="checkbox"/>	UPLOAD
<input type="checkbox"/>	BACK UP
<input type="checkbox"/>	LIST
<input type="checkbox"/>	CANCEL ACCESS FLAG
<input type="checkbox"/>	END

5301

FIG. 54

SELECTION OF MODEL			
<input type="checkbox"/> FILE(E) <input type="checkbox"/> EDIT(E) <input type="checkbox"/> VIEW(V) <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>			
PRODUCT NUMBER : BJ - 970909		NAME : 97 - 09 - 09 LOAD	
COMPONENT SYMBOL : CH		NAME :	
SET	MODEL	SYMBOL	QUANTITY
<input checked="" type="checkbox"/> A250 IQ <input type="checkbox"/> BJC - 4200 LX <input type="checkbox"/> BJC - 4200 SYSTEM <input type="checkbox"/> BJC - 420U <input type="checkbox"/> BJC - 420U(BLACK) <input type="checkbox"/> BJC - 4300 <input type="checkbox"/> BJC - 430U			
		NAME	
		PREVIOUS PUBLICATION DATE	
		1997/09/09 10:46:33	
<input type="checkbox"/> NEXT <input type="checkbox"/> REGISTER PUBLICATION <input type="checkbox"/> LOOK PUBLICATION <input type="checkbox"/> DISPLAY SAME MODEL <input type="checkbox"/> END			

FIG. 55

SELECTION OF MODEL									
FILE(F)		EDIT(E)		VIEW(V)					
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
PRODUCT SYMBOL : BJ-970909		NAME : 097-09 LOAD		SET MODEL SYMBOL : BJC-4300		LATEST REVISION NUMBER		UPDATE DISPLAY	
COMPONENT SYMBOL : ON		NAME :		NAME : x x x x x					
No.	FORMAL MANAGEMENT NO.	REVISION	UNIT WORK NAME	MANHOUR	USE	CS	FREQUENCY		
► N 3	CH-01-01	1	ELECTRIC CHECKING	0	0	0	0	1	
N 4	CH-01-02(1)	1	ELECTRIC CHECKING	0	0	0	0	1	
N 5	CH-01-02(2)	1	ELECTRIC CHECKING	0	0	0	0	1	
N 6	CH-01-03	1	ELECTRIC CHECKING	0	0	0	0	1	
N 7	CH-01-04	1	ELECTRIC CHECKING	0	0	0	0	1	
N 23	CH-07-02(1)	1	SET FRONT COVER	0	0	0	0	1	
N 24	CH-07-02(2)	1	SET FRONT COVER	0	0	0	0	1	
N 25	CH-07-01(3)	1	SET FRONT COVER	0	0	0	0	1	
N 26	CH-07-01(4)	1	SET FRONT COVER	0	0	0	0	1	
No.	FORMAL MANAGEMENT NO.	UNIT WORK NAME	MANHOUR	USE	FREQUENCY	1	2	3	4
3	CH-01-01	ELECTRICAL CHECK	0	0	1				
<input type="checkbox"/> CHANGE <input type="checkbox"/> INSERT <input type="checkbox"/> ADD <input type="checkbox"/> OK									

FIG. 56

XXXXXX	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
FORMAL MANAGEMENT NO. PU-03-01 UNIT WORK NAME : MOTOR ATTACHMENT TOTAL MANHOUR : <input type="checkbox"/> 0 <input type="checkbox"/> NEXT UNIT WORK						
NO.	ELEMENT WORK NAME	REVISION	MANHOUR	US	CS	SET CONDITION
1	SET DOUBLE GEAR TO OPPOSITE SIDE OF AXIS IN ORDER OF SMALL GEAR DIAMETER	1	0	0	0	
*						
COMMENT 1 : TO OPPOSITE SIDE OF AXIS						
OBJECT : DOUBLE GEAR						
COMMENT 2 : IN ORDER OF SMALL GEAR DIAMETER						
VERB : SET						
5604	5605	5603	5602	5601		

FIG. 57

EDITING OF ANALYSIS MATERIAL							
FILE[F]		EDIT[E]		VIEW[V]			
PRODUCT GENRE :		ALL		▼			
TYPE	COMMENT 1	OBJECT	COMMENT 2	VERB	ANALYSIS SYMBOL	MANHOUR	USEFREQ. COUNT
▶	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50(GrIN)>6<3	15	0 1 1 0
	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50(E[D2])>6<3	11	0 1 1 0
	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50(GrIN)>6<3	15	0 1 1 0
	ELEMENT	WORK 01	VERB	INSERT	-50(GrIN)>6<3	15	0 1 1 0
	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50(GrIN)>6<3	15	0 1 1 0
	CARRIAGE	LOCK	APPLY	Time100Rate100	100	100 1 1 1	
	ASSEMBLE	PRINTER CHASSIS	INSERT & SET	M2111/110	50	1 1 1 1	
	MOTOR	PRINTER CHASSIS	TURN INSIDE OUT	T1221/M2311/00	12	0 1 1 0	
1				T2221/M1211/01	24	0 1 1 0	
2				T1221/M2311/00	12	0 1 1 0	
	PRINTER	CHASSIS	ASSEMBLE PR GUIDE	SET	15	0 1 1 0	
	dgrafidafas		fasidastasfad	*	16	0 1 1 0	
	dsatidafas		fasidastasfad	T2112/M1111/01	13	0 1 1 0	
	dgrafidafas		fasidastasfad	*	16	0 1 1 0	
	PRINTER	CHASSIS	ASSEMBLE PR GUIDE	SET	15	0 1 1 0	
	PRINTER	CHASSIS	ASSEMBLE PR GUIDE	SET	15	0 1 1 0	
	PRINTER UNIT		SET	Time100Rate100	100	100 1 1 0	

FIG. 58

58/97

OPERATION ANALYSIS		SET MAIN BODY TO PREDERMINED POSITION		TOTAL SIMO VALUE: <input type="text" value="0"/>		TOTAL MANHOUR VALUE: <input type="text" value="15"/>		SIMO		NEXT ELEMENT WORK	
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
►	1	XXXXXX		WF/OS	SET CONDITION	MANHOUR	USE	REMARKS			
*				PU	-60/Gr1/N>6/3	15	0				

FIG. 59

5901	<input type="radio"/> 1. PU	<input type="radio"/> 6. DSY	<input type="radio"/> 11. PU	<input type="radio"/> 16. DSY
	<input type="radio"/> 2. GET	<input type="radio"/> 7. R	<input type="radio"/> 12. GET	<input type="radio"/> 17. R
	<input type="radio"/> 3. M	<input type="radio"/> 8. UMAC	<input type="radio"/> 13. M	
	<input type="radio"/> 4. MA	<input type="radio"/> 9. MP	<input type="radio"/> 14. MA	
	<input type="radio"/> 5. ASY	<input type="radio"/> 10. BODY	<input type="radio"/> 15. ASY	

SIMO

5902

FIG. 60

XXXXXX	PU	PICK UP	MANUAL																																																				
<table border="1"> <tr> <td>1 : MOVING DISTANCE</td> <td>1</td> <td>2</td> <td>3</td> <td>4</td> <td>5</td> <td>6</td> </tr> <tr> <td></td> <td>-10cm</td> <td>+10cm</td> <td>>50cm</td> <td></td> <td></td> <td></td> </tr> <tr> <td>2 : GRIP TYPE</td> <td>Or-3</td> <td>Or-2</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>3 : PRE-POSITIONING</td> <td>NO</td> <td>YES</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>4 : MAIN SIZE</td> <td>-10mm</td> <td>-8mm</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>5 : WEIGHT</td> <td><3kg</td> <td>>3kg</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>6 :</td> <td colspan="6"></td> </tr> </table>							1 : MOVING DISTANCE	1	2	3	4	5	6		-10cm	+10cm	>50cm				2 : GRIP TYPE	Or-3	Or-2					3 : PRE-POSITIONING	NO	YES					4 : MAIN SIZE	-10mm	-8mm					5 : WEIGHT	<3kg	>3kg					6 :						
1 : MOVING DISTANCE	1	2	3	4	5	6																																																	
	-10cm	+10cm	>50cm																																																				
2 : GRIP TYPE	Or-3	Or-2																																																					
3 : PRE-POSITIONING	NO	YES																																																					
4 : MAIN SIZE	-10mm	-8mm																																																					
5 : WEIGHT	<3kg	>3kg																																																					
6 :																																																							
<table border="1"> <tr> <td>SET</td> <td>CANCEL</td> <td>SET VALUE</td> <td>FORMULA</td> <td colspan="3"></td> </tr> <tr> <td>6001</td> <td>6002</td> <td>6003</td> <td></td> <td></td> <td></td> <td></td> </tr> </table>							SET	CANCEL	SET VALUE	FORMULA				6001	6002	6003																																							
SET	CANCEL	SET VALUE	FORMULA																																																				
6001	6002	6003																																																					

FIG. 61

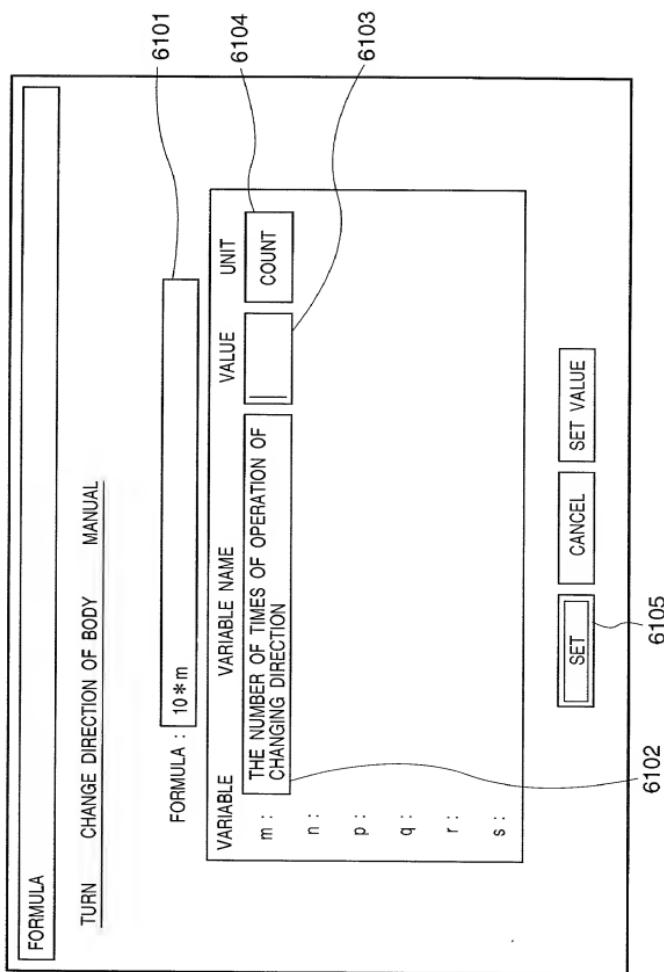


FIG. 62

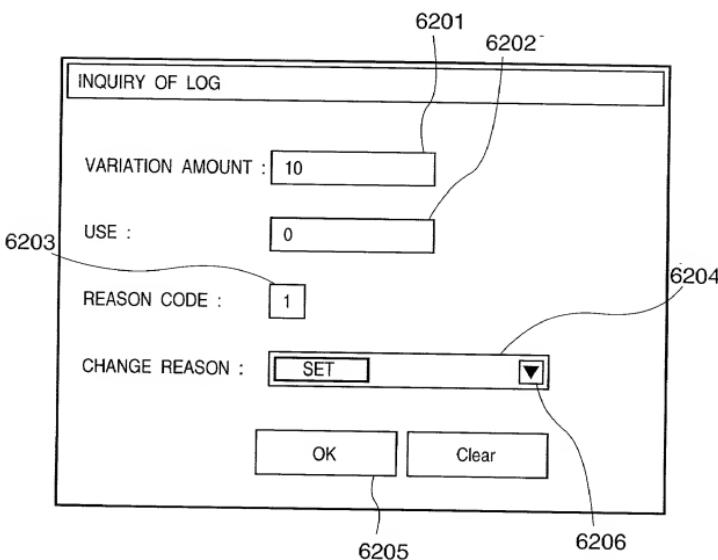


FIG. 63

CORRECTION OF CHANGE LOG

DATE

1997 09 22 O = O FROM
 BEFORE O ~

SEARCH

6301

6302

63/97

NO.	UNIT WORK NAME	CODE	CHANGE REASON	NEW MANHOUR	(NEW) MANUAL USE	(PREVIOUS) MANUAL USE	(PREVIOUS) USE	CHANGE	DATE
► CH-01-01	ELECTRICAL CHECK	1	SET	10	10	0	0	0	1997/09/22 14:30:00

REASON CODE 1 CHANGE REASON SET ▶

OK Cr END

FIG. 64

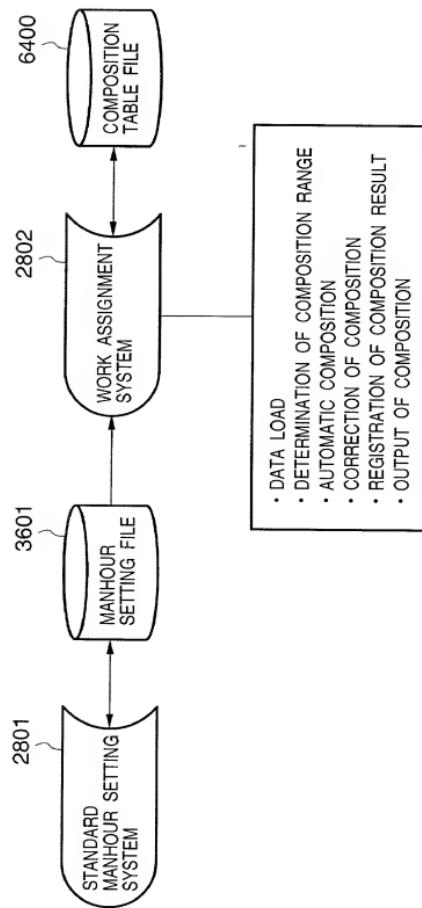


FIG. 65

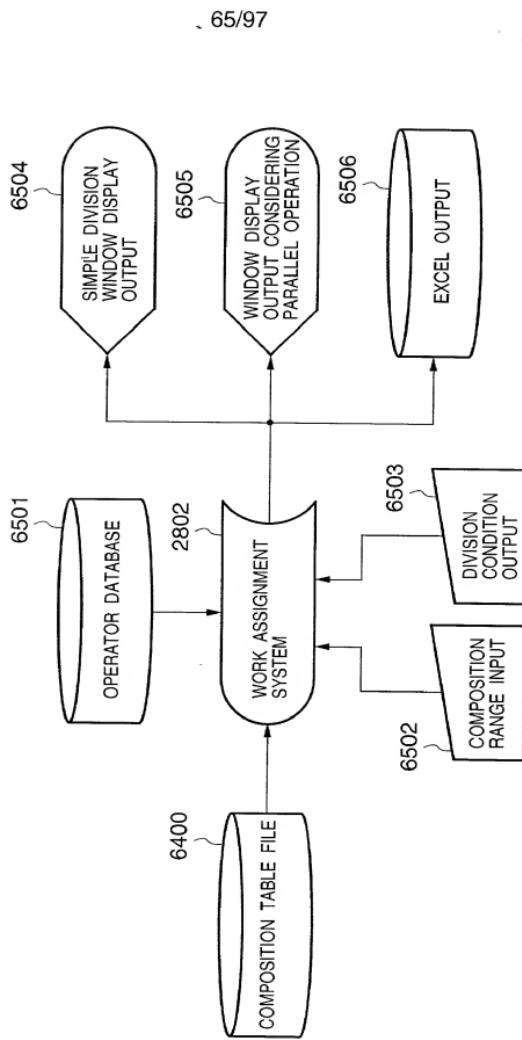


FIG. 66

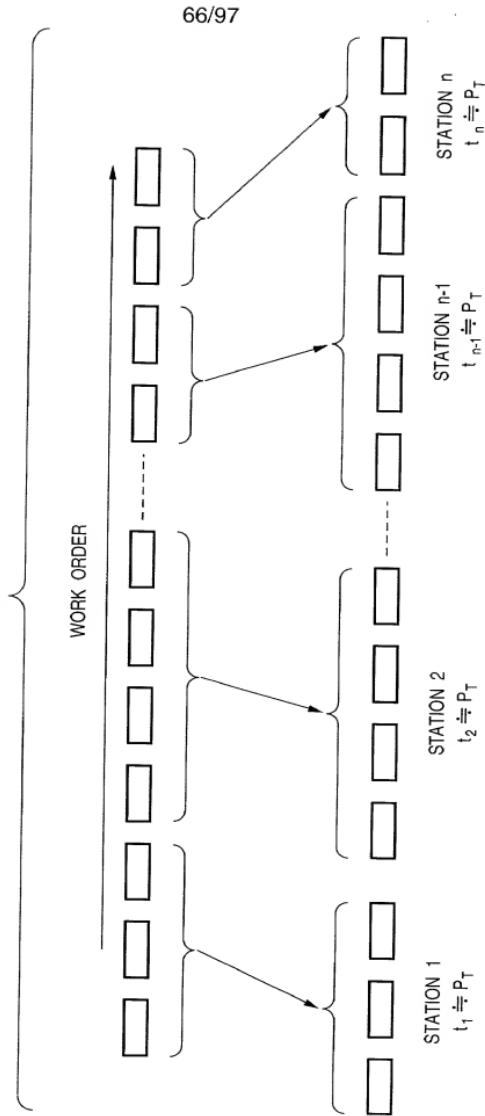


FIG. 67

67/97

FILE(F) EDIT(E) INPUT(I) TOOL(O)		◀ ▶
MODEL	GP55	
UNIT		
STANDARD NO.	WORK NAME	MANHOUR
0001	STICK HANDY CUT TAPE	134
0002	SET LABELS ON MAIN BODY	550
0003	WEIMAN REMOVAL	270
0004	ASSEMBLE OUTER CASE	365
0005	FIT TOP PAD	288
0006	STICK LARGE-SIDE ORDER LABEL	117
...		

FIG. 68

SIMPLE DIVISION

—		▼	▲
—	FILE(F) EDIT(E)	◆	◆

St 1

0001	STICK HANDY CUT TAPE	134
0002	SET LABELS ON MAIN BODY	550
0003	WEIMAN REMOVAL	270

St 2

0004	ASSEMBLE OUTER CASE	365
0005	FIT TOP PAD	268
0006	STICK LARGE-SIDE ORDER LABEL	117

FIG. 69

6901

FILE(F) EDIT(E)

COMPOSITION EFFICIENCY 92 %

tp $\times 1.05$

tp $\times 0.85$

RU

1 2 3 4 5 St

6902

FILE(F) EDIT(E)

St 1

0001	STICK HANDY CUT TAPE	134
0002	SET LABELS ON MAIN BODY	550
0003	WEIMAN REMOVAL	270

DRAG AND DROP

St 2

0004	ASSEMBLE OUTER CASE	365
0005	FIT TOP PAD	268
0006	STICK LARGE-SIDE ORDER LABEL	117

6903

OK CANCEL

FIG. 70

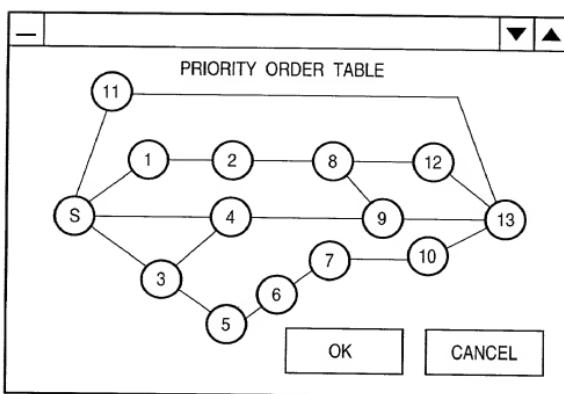


FIG. 71

PARALLEL DIVISION

PLAN 2

St 1	1	2	8
------	---	---	---

St 2

3	4	5
---	---	---

PLAN 1

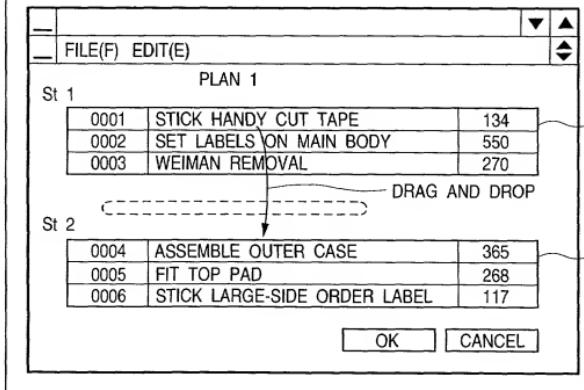
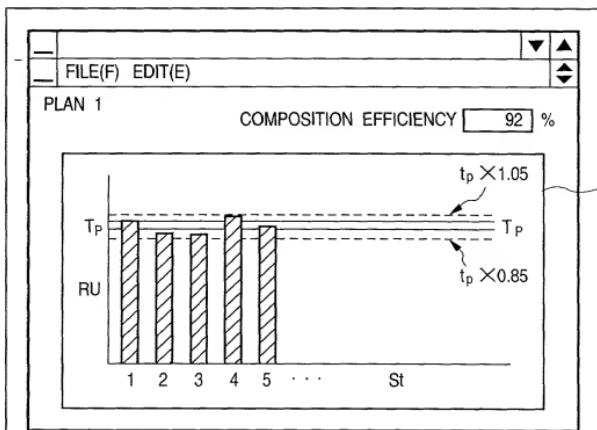
St 1

1	STICK HANDY CUT TAPE	99
2	SET LABELS ON MAIN BODY	78
3	WEIMAN REMOVAL	134

St 2

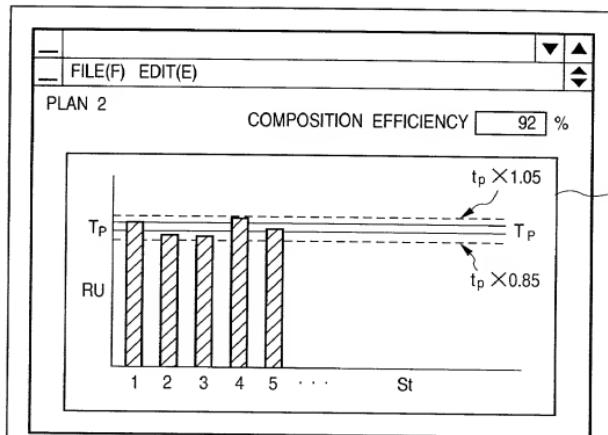
4	ASSEMBLE OUTER CASE	732
5	FIT TOP PAD	268
6	STICK LARGE-SIDE ORDER LABEL	117

FIG. 72



卷之三

FIG. 73



7301

FILE(F) EDIT(E)

PLAN 2

St 1	0001 STICK HANDY CUT TAPE	134
	0002 SET LABELS ON MAIN BODY	550
	0008 XXXX	270

St 2

0003 WEIMAN REMOVAL	365
0004 ASSEMBLE OUTER CASE	268
0005 FIT TOP PAD	117

DRAG AND DROP

OK CANCEL

7302

7303

FIG. 74

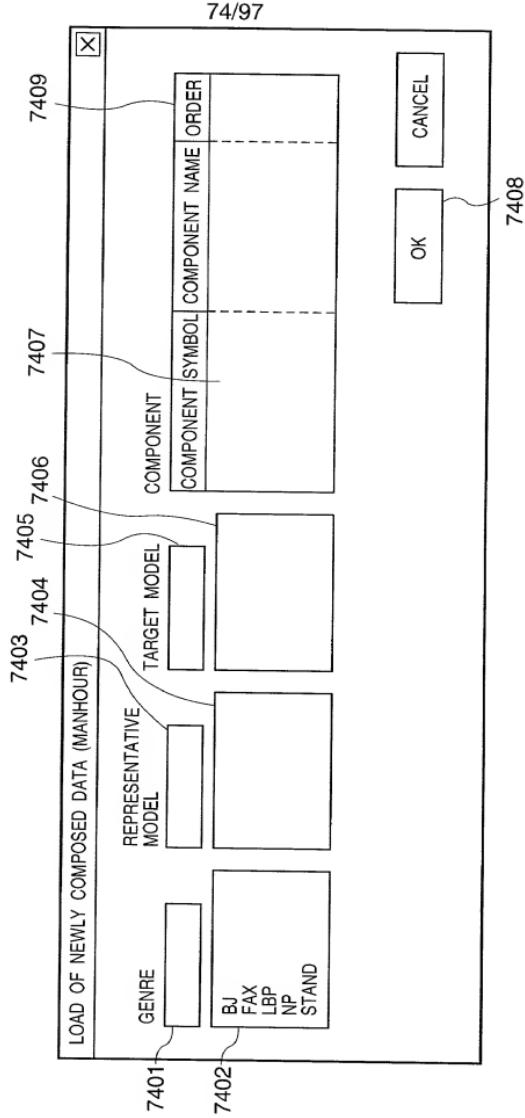


FIG. 75

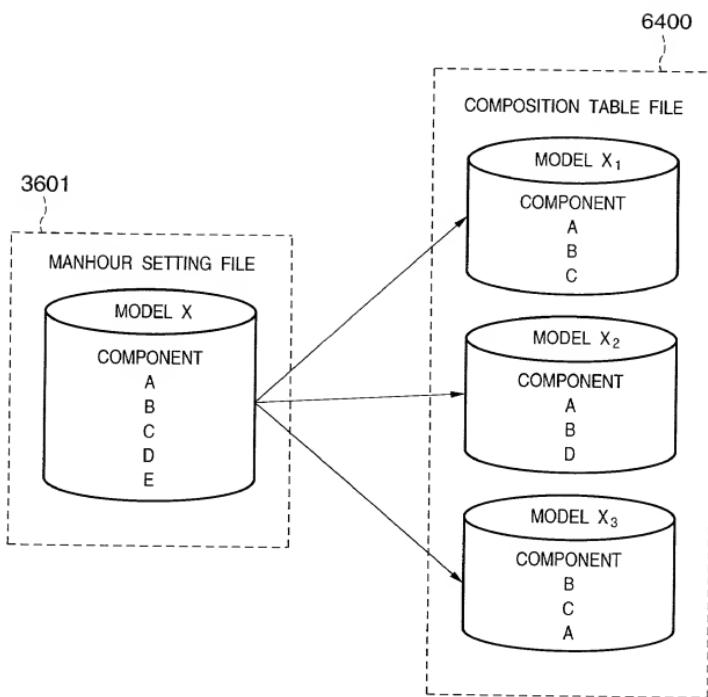


FIG. 76

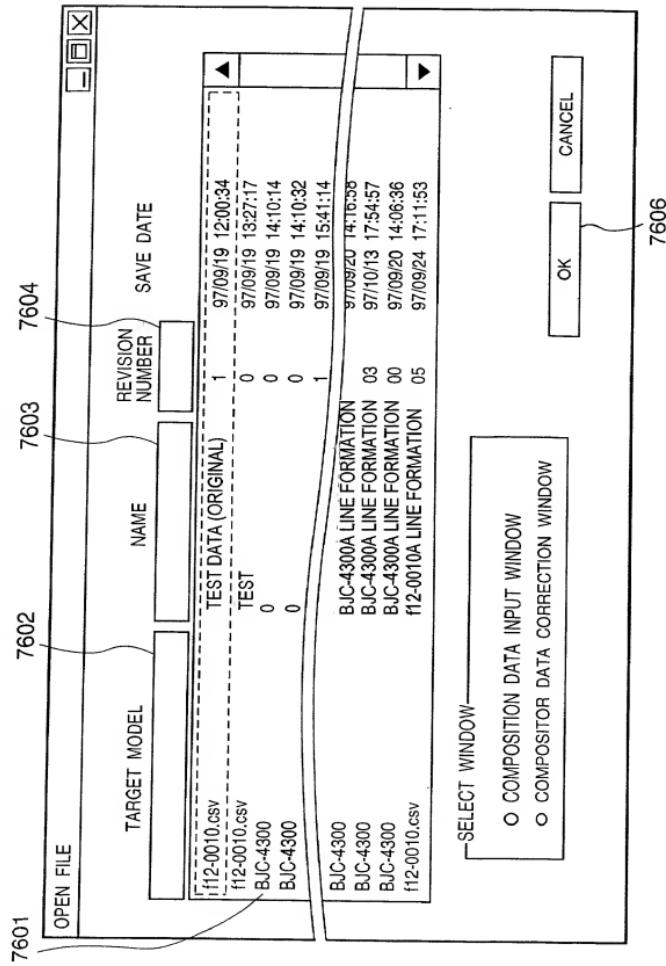


FIG. 78

456789012345678901

7801

7802

INSERTION OF UNIT WORK	
NEW WORK WILL BE INSERTED BEFORE "STICK CHECK SHEET SERIAL NO."	
INPUT WORK NAME AND PROVISIONAL MANHOUR VALUE	
UNIT WORK NAME :	<input type="text"/>
PROVISIONAL MANHOUR :	<input type="text"/> (RU)
REMARKS :	<input type="text"/>
<input type="button" value="OK"/> <input type="button" value="CANCEL"/>	

FIG. 79

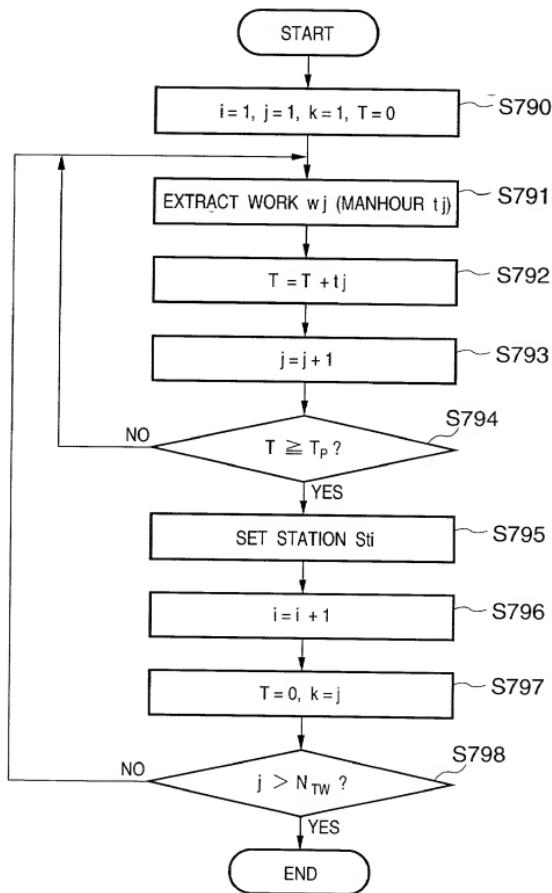


FIG. 80

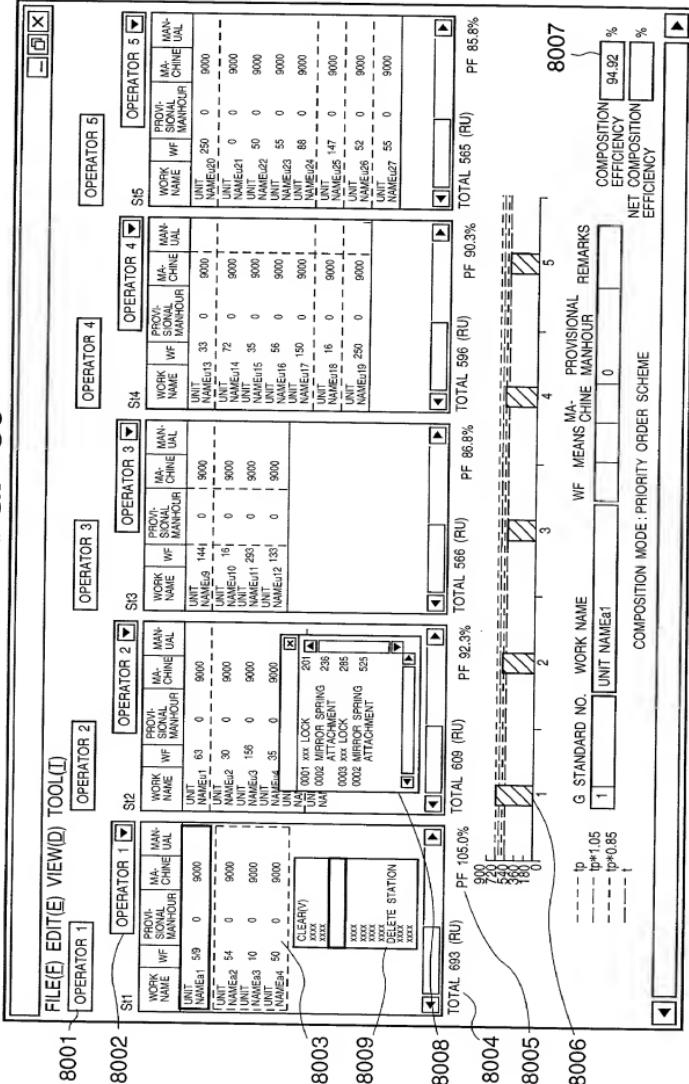
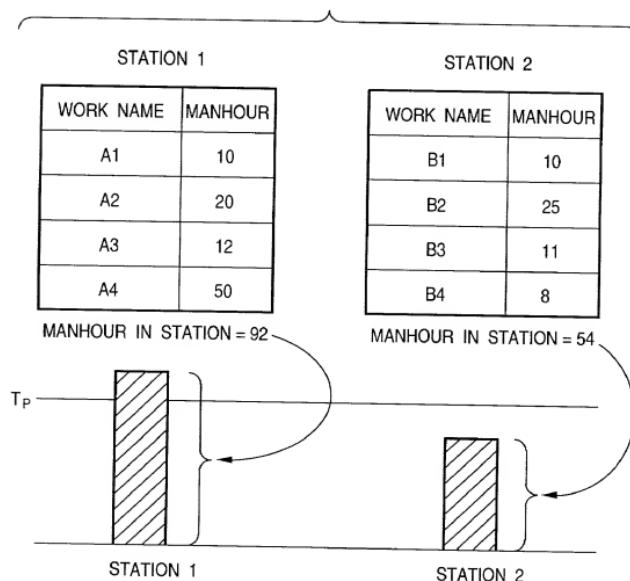


FIG. 81



F I G. 82

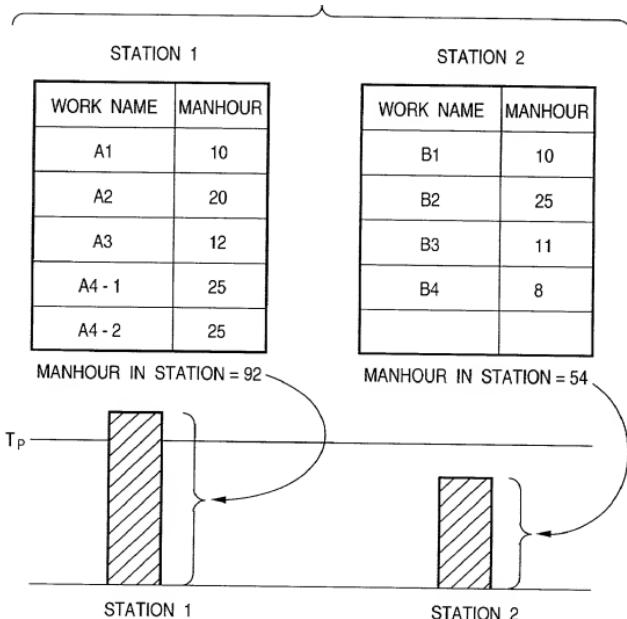


FIG. 83

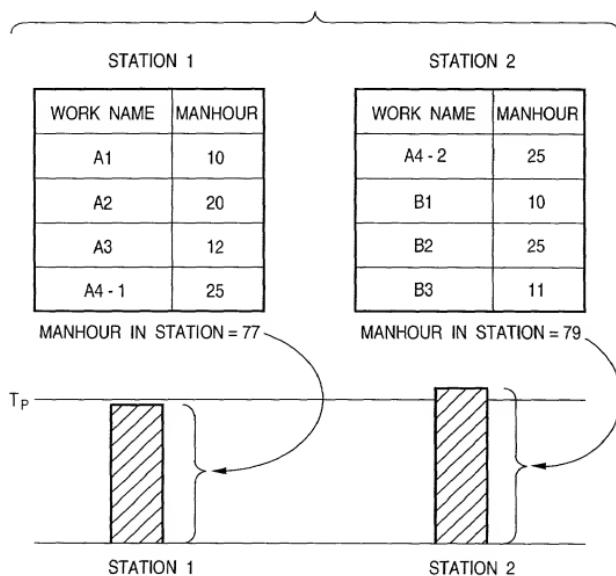


FIG. 84

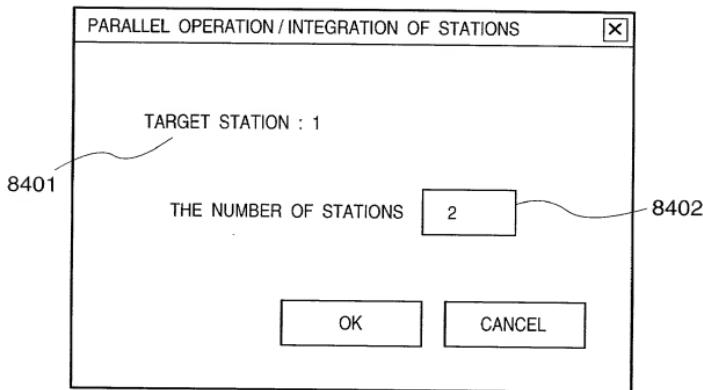


FIG. 85

FILE(E) EDIT(E) VIEW(D) TOOL(T)		OPERATOR 1		OPERATOR 2		OPERATOR 3		OPERATOR 4		OPERATOR 5	
WORK NAME	PROV. WF SIGNAL MAN-CHINE HAL	WORK NAME	PROV. WF SIGNAL MAN-CHINE HAL	WORK NAME	PROV. WF SIGNAL MAN-CHINE HAL	WORK NAME	PROV. WF SIGNAL MAN-CHINE HAL	WORK NAME	PROV. WF SIGNAL MAN-CHINE HAL	WORK NAME	PROV. WF SIGNAL MAN-CHINE HAL
START	0	0	No								
UNIT WORK	34	10	No 01	UNIT WORK	15	0	No 03	UNIT WORK	34	0	No 04
NAME 1				NAME 4				NAME 7			
UNIT WORK	25	46	No 02	UNIT WORK	18	23	No 06	UNIT WORK	71	48	No 10
NAME 2				NAME 9				NAME 10			
UNIT WORK	92	26	No 06	UNIT WORK	30	30	No 11	UNIT WORK	138	30	No 11
NAME 5				NAME 11				NAME 12			
UNIT WORK	52	0	No 07	UNIT WORK	97	20	No 21	UNIT WORK	88	0	No 14
NAME 6				NAME 13				NAME 14			
UNIT WORK	62	0	No 08	UNIT WORK	46	18	No 15	UNIT WORK	546	15	No 16
NAME 7				NAME 15				NAME 16			
UNIT WORK	0	36	No 09	UNIT WORK	58	20	No 17	UNIT WORK	58	20	No 17
NAME 8				NAME 17				NAME 18			
UNIT WORK				NAME 19				NAME 20			
NAME 9				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 21				NAME 22			
NAME 10				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 23				NAME 24			
NAME 11				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 25				NAME 26			
NAME 12				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 27				NAME 28			
NAME 13				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 29				NAME 30			
NAME 14				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 31				NAME 32			
NAME 15				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 33				NAME 34			
NAME 16				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 35				NAME 36			
NAME 17				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 37				NAME 38			
NAME 18				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 39				NAME 40			
NAME 19				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 41				NAME 42			
NAME 20				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 43				NAME 44			
NAME 21				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 45				NAME 46			
NAME 22				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 47				NAME 48			
NAME 23				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 49				NAME 50			
NAME 24				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 51				NAME 52			
NAME 25				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 53				NAME 54			
NAME 26				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 55				NAME 56			
NAME 27				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 57				NAME 58			
NAME 28				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 59				NAME 60			
NAME 29				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 61				NAME 62			
NAME 30				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 63				NAME 64			
NAME 31				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 65				NAME 66			
NAME 32				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 67				NAME 68			
NAME 33				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 69				NAME 70			
NAME 34				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 71				NAME 72			
NAME 35				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 73				NAME 74			
NAME 36				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 75				NAME 76			
NAME 37				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 77				NAME 78			
NAME 38				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 79				NAME 80			
NAME 39				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 81				NAME 82			
NAME 40				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 83				NAME 84			
NAME 41				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 85				NAME 86			
NAME 42				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 87				NAME 88			
NAME 43				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 89				NAME 90			
NAME 44				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 91				NAME 92			
NAME 45				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 93				NAME 94			
NAME 46				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 95				NAME 96			
NAME 47				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 97				NAME 98			
NAME 48				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 99				NAME 100			
NAME 49				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 101				NAME 102			
NAME 50				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 103				NAME 104			
NAME 51				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 105				NAME 106			
NAME 52				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 107				NAME 108			
NAME 53				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 109				NAME 110			
NAME 54				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 111				NAME 112			
NAME 55				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 113				NAME 114			
NAME 56				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 115				NAME 116			
NAME 57				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 117				NAME 118			
NAME 58				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 119				NAME 120			
NAME 59				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 121				UNIT WORK			
NAME 60				UNIT WORK				NAME 122			
UNIT WORK				NAME 123				UNIT WORK			
NAME 61				UNIT WORK				NAME 124			
UNIT WORK				NAME 125				UNIT WORK			
NAME 62				UNIT WORK				NAME 126			
UNIT WORK				NAME 127				UNIT WORK			
NAME 63				UNIT WORK				NAME 128			
UNIT WORK				NAME 129				UNIT WORK			
NAME 64				UNIT WORK				NAME 130			
UNIT WORK				NAME 131				UNIT WORK			
NAME 65				UNIT WORK				NAME 132			
UNIT WORK				NAME 133				UNIT WORK			
NAME 66				UNIT WORK				NAME 134			
UNIT WORK				NAME 135				UNIT WORK			
NAME 67				UNIT WORK				NAME 136			
UNIT WORK				NAME 137				UNIT WORK			
NAME 68				UNIT WORK				NAME 138			
UNIT WORK				NAME 139				UNIT WORK			
NAME 69				UNIT WORK				NAME 140			
UNIT WORK				NAME 141				UNIT WORK			
NAME 70				UNIT WORK				NAME 142			
UNIT WORK				NAME 143				UNIT WORK			
NAME 71				UNIT WORK				NAME 144			
UNIT WORK				NAME 145				UNIT WORK			
NAME 72				UNIT WORK				NAME 146			
UNIT WORK				NAME 147				UNIT WORK			
NAME 73				NAME 148	xxxxxx	PF 23.5%		UNIT WORK			
UNIT WORK				NAME 149				NAME 150			
NAME 74				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 151				NAME 152			
NAME 75				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 153				NAME 154			
NAME 76				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 155				NAME 156			
NAME 77				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 157				NAME 158			
NAME 78				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 159				NAME 160			
NAME 79				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 161				NAME 162			
NAME 80				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 163				NAME 164			
NAME 81				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 165				NAME 166			
NAME 82				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 167				NAME 168			
NAME 83				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 169				NAME 170			
NAME 84				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 171				NAME 172			
NAME 85				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 173				NAME 174			
NAME 86				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 175				NAME 176			
NAME 87				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 177				NAME 178			
NAME 88				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 179				NAME 180			
NAME 89				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 181				NAME 182			
NAME 90				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 183				NAME 184			
NAME 91				UNIT WORK				UNIT WORK			
UNIT WORK				NAME 185		</td					

FIG. 86

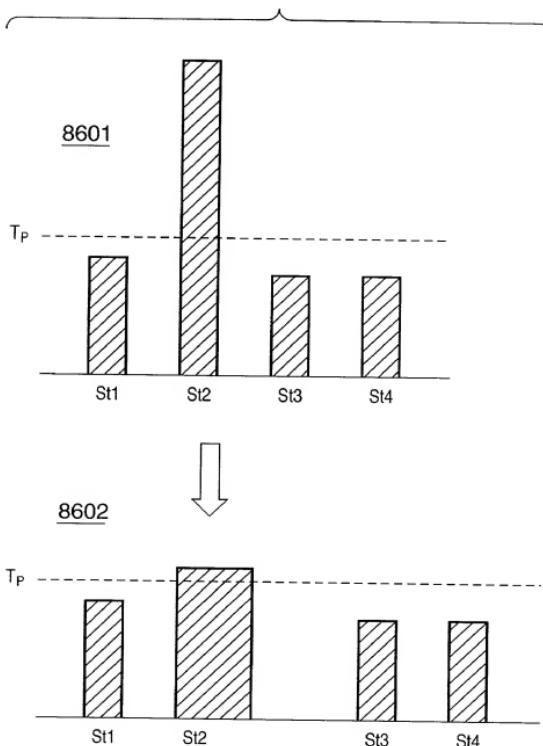


FIG. 87

USER REGISTRATION

NAME CODE :	<input type="text" value="12345"/>	8701
NAME :	<input type="text" value="TANAKA"/> <input type="text" value="ICHIRO"/>	8702
POSITION :	<input type="text" value="kumitate"/> <input type="button" value="▼"/>	8703
PASSWORD :	<input type="text" value="12345"/>	8704
AUTHORITY :	<input type="text"/>	8705

FIG. 88

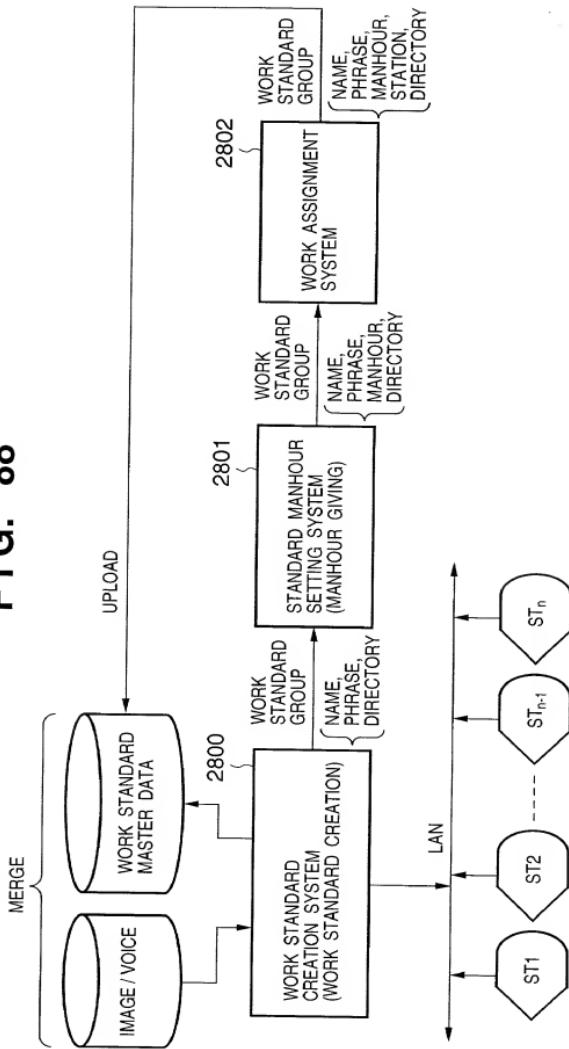


FIG. 89

DIRECTORY NAME	IMAGE DATA	OPERATION (VERB)	PARAMETER 1	PARAMETER 2	PARAMETER 3
xxxxxx1	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 10mm	TORQUE 10kg.M
xxxxxx2	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TORQUE 20kg.M
xxxxxx3	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TORQUE 30kg.M
...
yyyyyy1	ROTATE	ROTATE	CLOCKWISE	DISTANCE MOVEMENT 20mm	
yyyyyy2	ROTATE	ROTATE	COUNTERCLOCKWISE	DISTANCE MOVEMENT 20mm	
...
zzzzzz1	OPEN	OPEN	OPEN UPWARD	DISTANCE MOVEMENT 30mm	WEIGHT 100g
zzzzzz2	OPEN	OPEN	OPEN DOWNWARD	DISTANCE MOVEMENT 40mm	WEIGHT 200g
...

FIG. 90

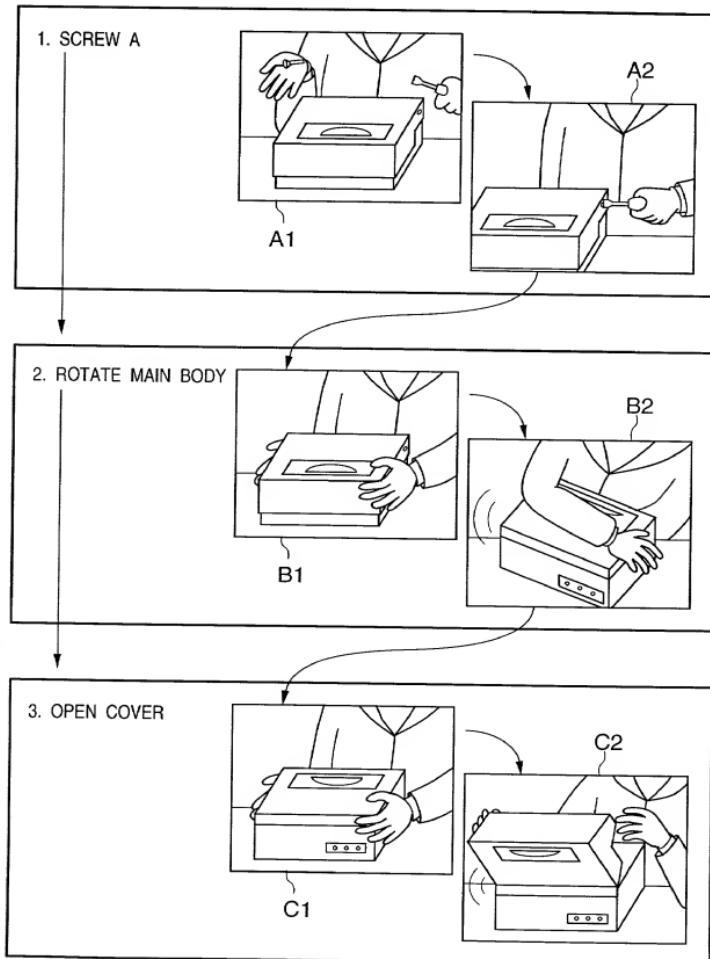


FIG. 91

9101 9102

SETTING OF COMPONENT SYMBOL		
PRODUCT SYMBOL :	BJ - 970909	
COMPONENT SYMBOL :	<input type="text" value="CH"/>	
COMPONENT NAME :	<input type="text" value="CHECK"/>	
<input type="button" value="OK"/>	<input type="button" value="SEARCH COMPONENT"/>	<input type="button" value="CANCEL"/>

FIG. 92

WORK GROUP DESIGNATION FOR ② AND ③

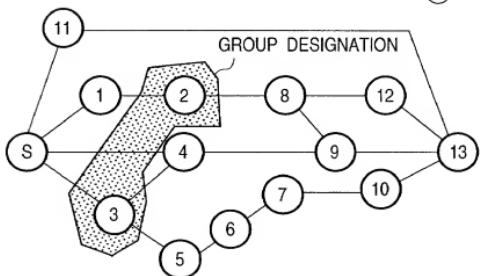


FIG. 93

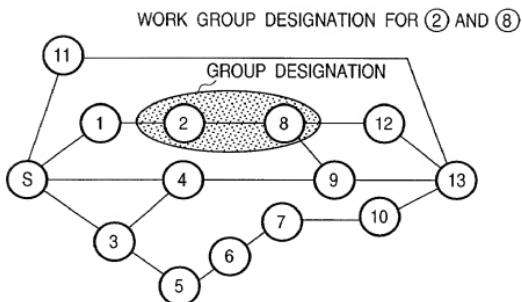


FIG. 94

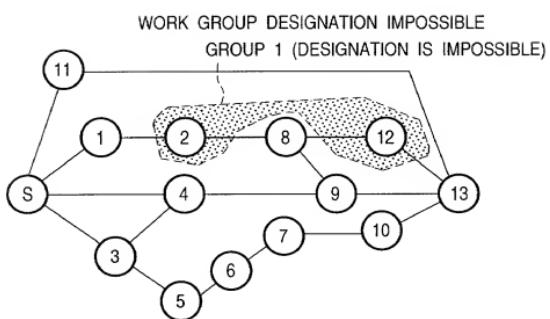
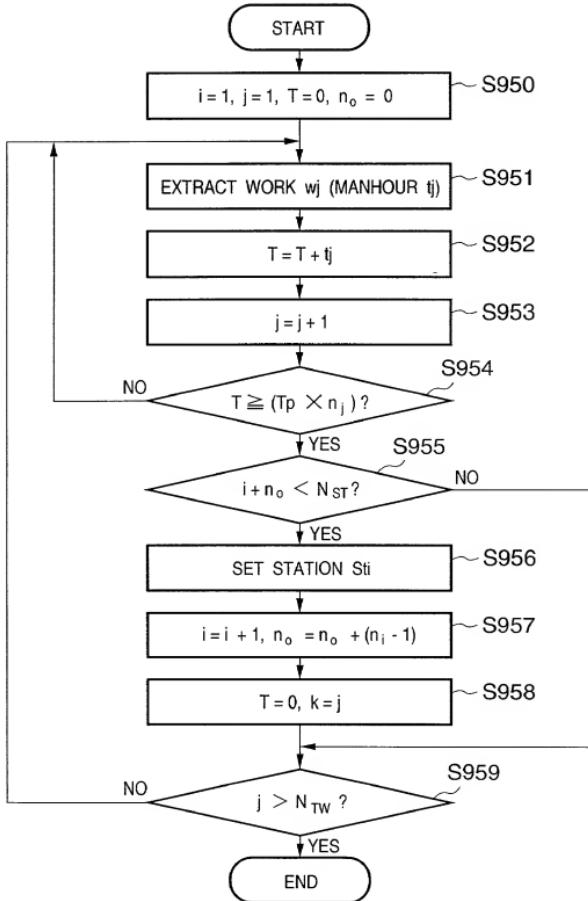


FIG. 95

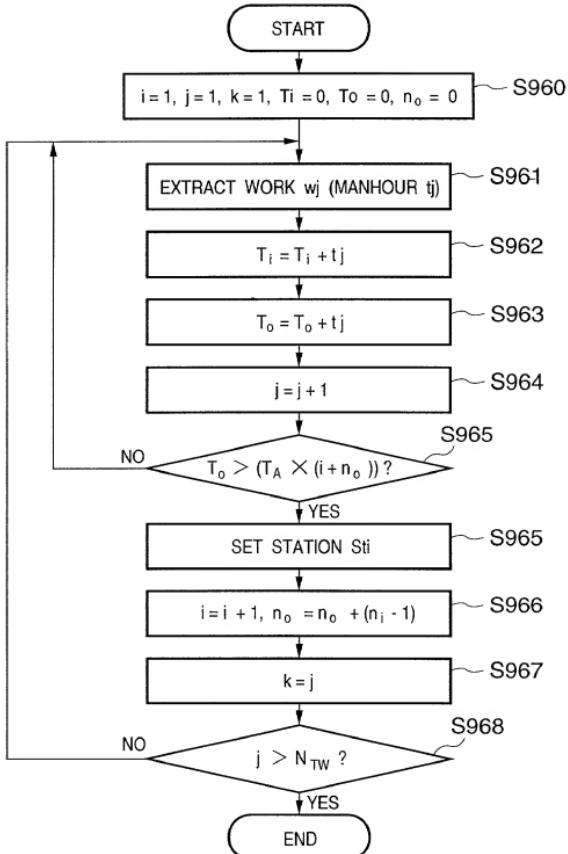


N_{ST} : THE NUMBER OF STATIONS

n_i : i STATION PARALLEL NUMBER

n_o : TOTAL ACCUMULATED PARALLEL SUM NUMBER

FIG. 96



N_{ST} : THE NUMBER OF STATIONS

T_i : i STATION MANHOUR

TA : STATION MANHOUR AVERAGE VALUE

$$T_A = WF / N_{ST}$$

T_o : TOTAL ACCUMULATED MANHOUR

n_i : i STATION PARALLEL NUMBER

n_o : TOTAL ACCUMULATED PARALLEL SUM NUMBER

FIG. 97